

Work Order ID 66051

Thursday, February 03, 2011 11:31:08 AM

Page 1

Item ID: DSI 9542-041

Accept

Revision ID: PRELIM

Item Name: Basket Modification

Start Date: 2/4/2011 Start Qty: 1.00

Required Date: 2/11/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: MF

Date: 11-02-03 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9448

A

DSI 9542

~~PAS~~

~~11.02.04~~

~~PAS~~

~~11.02.14~~

A

0.00

100



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & type labels per PPP DSI 9542-041 CHG001

TO BE SENT TO CUSTOMER AFTER
RELEASE OF DWGS.

P10 →

110



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: 111585 0.00

Memo

0.00

Disassemble basket and keep the hardware

1- Make cut out in mesh as per DSI

2- Remove powdercoat in area to be welded

3- Locate plates, retainers and tube assembly as per DSI, weld as per DSI9542

When welding tubes assembly on bottom of basket base make sure that all tubes must be level the same

~~4- Replace hinges in accordance with DSI9448~~

Pl 11.02.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod.Mgr'	Approval QC Inspector

Part No: DS19542-041 PAR #: N/A Fault Category: Large Fab. NCR: Yes No DQA: Yes Date: 11-03-03
 Resolution: acceptable Disposition: use as is QA: N/C Closed: Yes Date: 11/03/04

NCR: 66051		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/02/15	#100	Found @ QCS that the center D437-043 was welded in wrong location. It should be from inside of Rib 15.50" but measured 14.75" Also the 3 D437-043 that are welded on the center Rib are						S 11/02/15
		on the wrong side to the Dwg. R.C. on first mistake (15.50") welded measured from outside the Rib. Lack of attention / operator error the second operator miss read the Dwg.	11.02.15 GS1042	ACCEPTABLE DEVIATION. HOLES IN LOWER ARE TRANSFER DRILLED TO MATCH.	lpl 11-02-15	S 11/02/15	11.02.15	S 11/02/15
		Lack of attention / operator error						S 11/02/15

NOTE: Date & initial all entries

Work Order ID 66051

Thursday, February 03, 2011 11:31:08 AM



Page 2

Item ID: DSI 9542-041

Accept



Setup Start



Revision ID: PRELIM

Item Name: Basket Modification

Stop



Start Date: 2/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

11.02.15

11/02/15 (1x)

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O
Packaging

0.00

Memo

0.00

-inspected to Rev
Prelim A3
Dry only
8/10/2015

140



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

1 8/10/2015

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66051

Thursday, February 03, 2011 11:31:08 AM

Page 3

Item ID: DSI 9542-041
Revision ID: PRELIM
Item Name: Basket Modification

Accept

Setup Start

Stop

Start Date: 2/4/2011 Start Qty: 1.00

Required Date: 2/11/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

POWDER COAT:

Start Time: 8:10 AM

Oven Temperature: 400°F

Finish Time: 8:40 PM

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

0.00



Small Fab

Memo

0.00

Small Fab

REASSEMBLE BASKET USING SAME HARDWARE

11-02-16 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66051

Thursday, February 03, 2011 11:31:08 AM



Page 4

Item ID: DSI 9542-041

Accept



Setup Start



Revision ID: PRELIM

Item Name: Basket Modification

Stop



Start Date: 2/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00 *inspect to P23*

Memo

0.00

*Day only**8/10/02/17*

190



Packaging

Packaging

Memo

Identify and pack for shipping as per PPP DSI 9542-041
Location: _____

0.00

0.00

*\$10 103706**customer
plan*

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*11/03/03**U 103-01*

POSITIVE RECALL

EFFECTIVE *11/02/03* AUTH *le*RELEASED *if* DATE *11.03.03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, February 03, 2011 11:31:05 AM

Page 1

Work Order ID: 66051

Parent Item: DSI 9542-041

Parent Item Name: Basket Modification









Start Date: 2/4/2011

Required Date: 2/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.02.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-540-013 <i>CM (customer m241)</i>  Heli-Utility-Basket		Manufactured	No			110	Each	1.0000	1	1			
<i>SEE DSI 9448-011 B66243</i>													
				<u>Location</u>				<u>Loc Qty</u>					
				BSKT				1					
					58598			1					
D4316-041  Tube Assembly		Manufactured	No			110	Each	0.0000	4	4			
D4317-011 <i>041</i>  Cover Panel Retainer		Manufactured	No			110	Each	0.0000	12	12			
D4317-012 <i>043</i>  Cover Panel Retainer		Manufactured	No			110	Each	0.0000	4	4			
D4317-1  Viewing Plate		Manufactured	No			110	Each	0.0000	1	1			
D4317-3  Wiring Plate		Manufactured	No			110	Each	0.0000	1	1			
D4317-5  GPS Plate		Manufactured	No			110	Each	0.0000	1	1			
DSI 9448-011  Hinge Upgrade		Manufactured	No			110	Each	0.0000	1	1			

B66057 → ④ pl 11.02.15

B66058 → ⑫ pl 11.02.15

B66061 → ④ pl 11.02.15

B66352 → ① pl 11.02.15

B66353 → ① pl 11.02.15

B66354 → ① pl 11.02.15

66243 N/A

no longer on DSI - spare here

see B 66243 (DSI 9448-011)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D206-540 REV. J

REF CANADIAN STC: SH94-5

REF FAA STC: SR00386NY

REF GERMAN STC: LBA RC 1124

PURPOSE

THIS DART SERVICE INSTRUCTION PROVIDES PARTS AND INSTRUCTIONS FOR MODIFYING A D206-540-013 HELI-UTILITY-BASKET FOR INSTALLATION OF SCANNING EQUIPMENT.

MODIFICATION PROCEDURE:

- 1) DISASSEMBLE BASKET AND RETAIN HARDWARE.
- 2) LOCATE THE D4317-1 VIEWING PLATE AND D4317-3 WIRING PLATE AND TRIM EXPANDED METAL AS SHOWN IN FIGURE 1 AND SECTIONS A-A & B-B. REMOVE FINISH ON EXPANDED METAL LOCALLY AND TIG WELD (TACK WELD) D4317-1 AND D4317-3 TO THE EXPANDED METAL, PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L OR ER316L FILLER ROD.
- 3) LOCATE THE D4317-5 GPS PLATE AND TRIM EXPANDED METAL AS SHOWN IN SECTION C-C. REMOVE FINISH ON THE BASKET LID TUBULAR STRUCTURE AND EXPANDED METAL LOCALLY. TIG WELD (FILLET & TACK WELD) D4317-5 TO THE TUBULAR STRUCTURE AND EXPANDED METAL AS SHOWN IN FIGURE 1, PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L OR ER316L FILLER ROD.
- 4) LOCATE D4317-041/-043 AS SHOWN IN SECTION C-C. REMOVE FINISH ON THE BASKET LID TUBES LOCALLY AND TIG WELD THE D4317-041/-043 COVER PANEL RETAINERS IN PLACE PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L OR ER316L FILLER ROD.
- 5) LOCATE QTY (4) D4136-041 TUBE ASSEMBLIES AS SHOWN IN SECTION D-D. REMOVE FINISH ON THE BASKET BASE HOOPS LOCALLY AND TIG WELD THE D4136-041 TUBE ASSEMBLIES IN PLACE PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L OR ER316L FILLER ROD.
- 6) TOUCH UP POWDER COAT OF AFFECTED AREAS ON BOTH LID AND BASE WITH WHITE POWDER COAT (4.3.5.2) PER DART QSI 005 4.3 OR PRIME/PAINT PER AIRCRAFT MAINTENANCE MANUAL.
- 7) RE-ASSEMBLE BASKET PER D206-540 REV J. REPLACE ANY WORN HARDWARE AS NECESSARY.

WEIGHT CHANGE:

THIS MODIFICATION ADDS 4.5 LBS TO THE WEIGHT OF THE BASKET WHICH REDUCES THE CARGO CARRYING CAPACITY OF THE BASKET BY 4.5 LBS.

NOTE:

IF A BASKET MODIFIED PER DSI 9542 IS GOING TO BE USED TO CARRY LOOSE CARGO THE CUTOUTS IN THE EXPANDED METAL FOR D4317-1 & D4317-3 MUST BE COVERED WITH BLANKING PLATES.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01
APPROVED

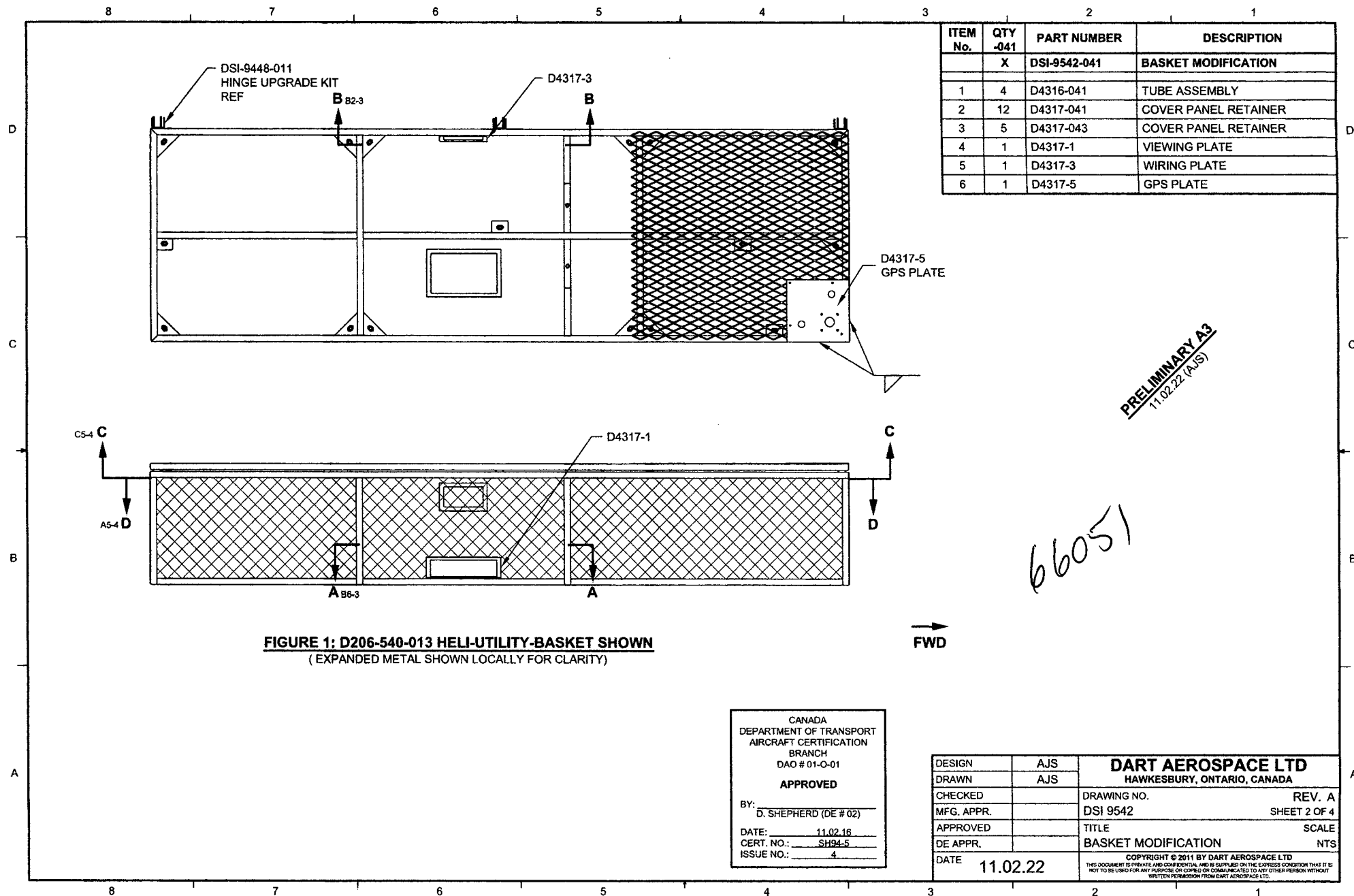
BY: D. SHEPHERD (DE # 02)

DATE: 11.02.16

CERT. NO.: SH94-5

ISSUE NO.: 4

A	SHT 2 BOM ITEM 3 QTY WAS 4	AJS	11.02.22
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9542	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET MODIFICATION	NTS
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ITEM No.	QTY -041	PART NUMBER	DESCRIPTION
	X	DSI-9542-041	BASKET MODIFICATION
1	4	D4316-041	TUBE ASSEMBLY
2	12	D4317-041	COVER PANEL RETAINER
3	5	D4317-043	COVER PANEL RETAINER
4	1	D4317-1	VIEWING PLATE
5	1	D4317-3	WIRING PLATE
6	1	D4317-5	GPS PLATE

PRELIMINARY A3
11.02.22 (AJS)

66051

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01

APPROVED

BY: D. SHEPHERD (DE # 02)

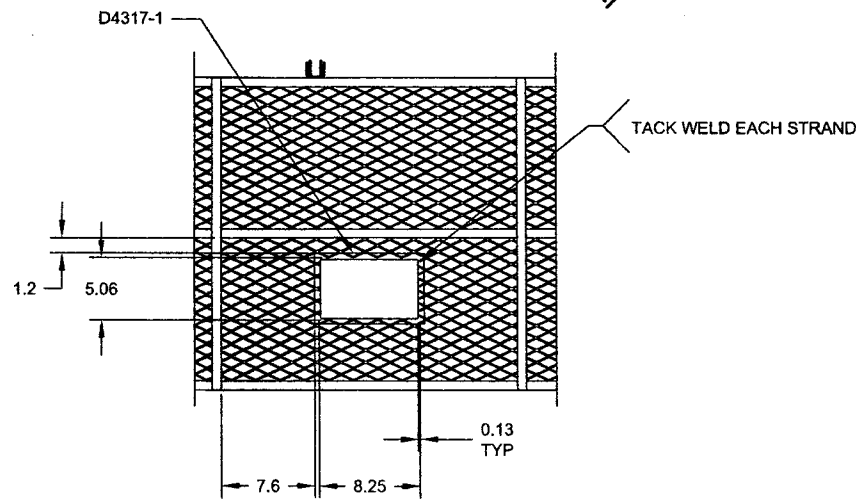
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CERT. NO.: SH94-5

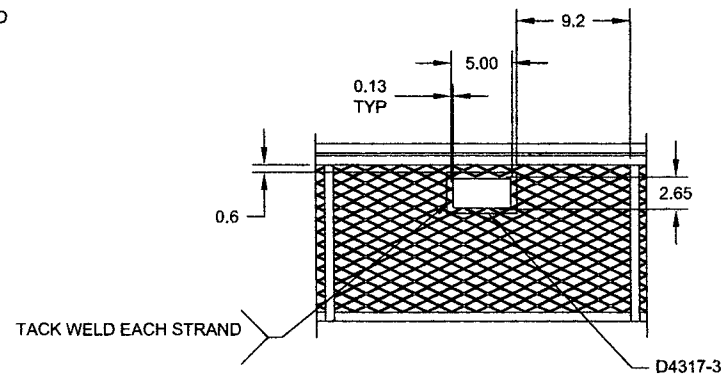
ISSUE NO.: 4

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9542	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET MODIFICATION	NTS
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PRELIMINARY A3
11.02.22 (AJS)



SECTION A-A B6-2

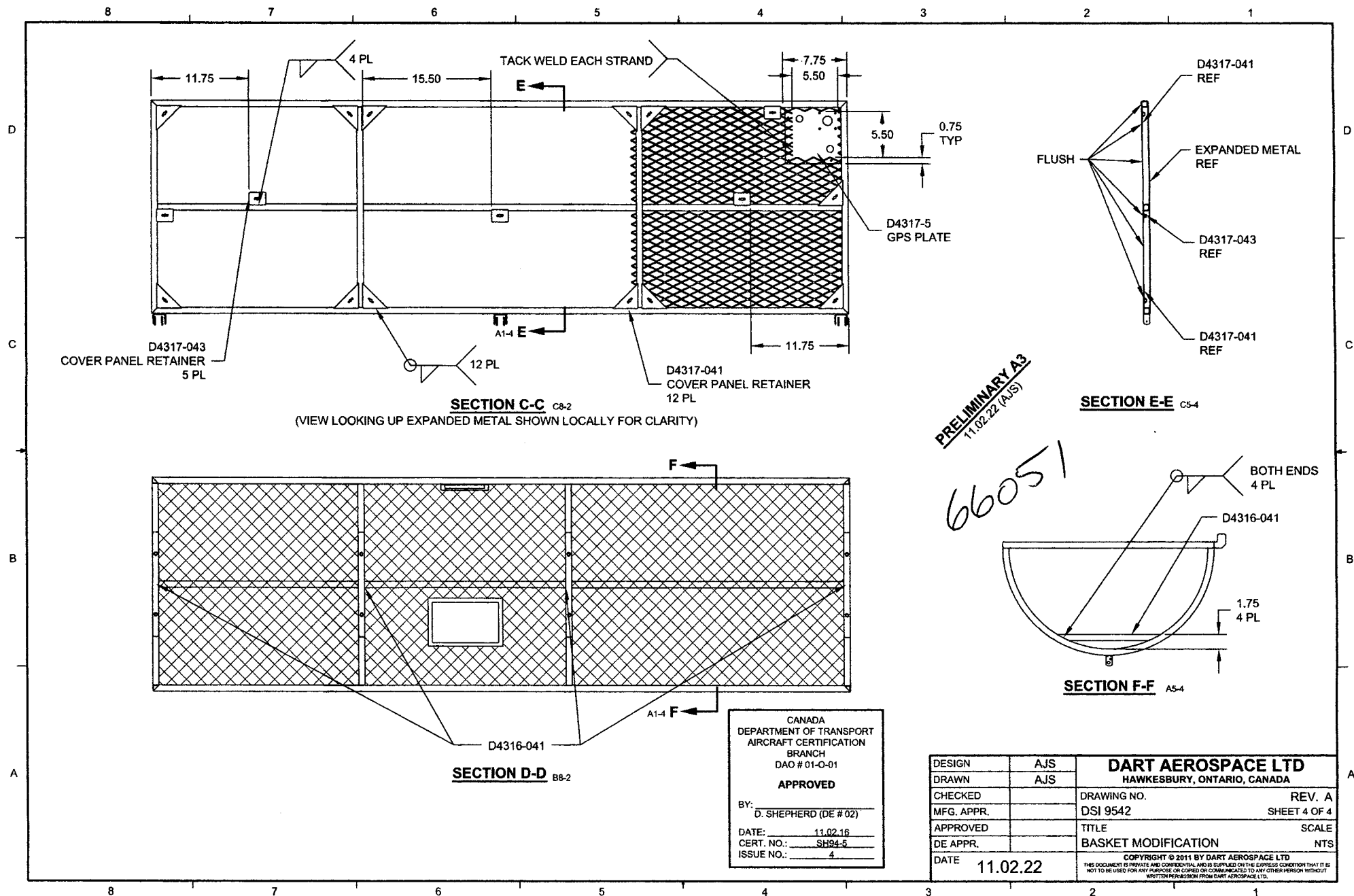


SECTION B-B D6-2

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01
APPROVED
BY: D. SHEPHERD (DE # 02)
DATE: 11.02.16
CERT. NO.: SH94-5
ISSUE NO.: 4

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9542	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET MODIFICATION	NTS
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66051



DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D206-540 REV. J

REF CANADIAN STC: SH94-5

REF FAA STC: SR00386NY

REF GERMAN STC: LBA RC 1124

PURPOSE

THIS DART SERVICE INSTRUCTION PROVIDES PARTS AND INSTRUCTIONS FOR MODIFYING A D206-540-013 HELI-UTILITY-BASKET FOR INSTALLATION OF SCANNING EQUIPMENT.

MODIFICATION PROCEDURE:

- 1) DISASSEMBLE BASKET AND RETAIN HARDWARE.
- 2) LOCATE THE D4317-1 VIEWING PLATE AND D4317-3 WIRING PLATE AND TRIM EXPANDED METAL AS SHOWN IN FIGURE 1 AND SECTIONS A-A & B-B. REMOVE FINISH ON EXPANDED METAL LOCALLY AND TIG WELD (TACK WELD) D4317-1 AND D4317-3 TO THE EXPANDED METAL, PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L OR ER316L FILLER ROD.
- 3) LOCATE THE D4317-5 GPS PLATE AND TRIM EXPANDED METAL AS SHOWN IN SECTION C-C. REMOVE FINISH ON THE BASKET LID TUBULAR STRUCTURE AND EXPANDED METAL LOCALLY. TIG WELD (FILLET & TACK WELD) D4317-5 TO THE TUBULAR STRUCTURE AND EXPANDED METAL AS SHOWN IN FIGURE 1, PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L OR ER316L FILLER ROD.
- 4) LOCATE D4317-041/-043 AS SHOWN IN SECTION C-C. REMOVE FINISH ON THE BASKET LID TUBES LOCALLY AND TIG WELD THE D4137-041/-043 COVER PANEL RETAINERS IN PLACE PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L OR ER316L FILLER ROD.
- 5) LOCATE QTY (4) D4136-041 TUBE ASSEMBLIES AS SHOWN IN SECTION D-D. REMOVE FINISH ON THE BASKET BASE HOOPS LOCALLY AND TIG WELD THE D4136-041 TUBE ASSEMBLIES IN PLACE PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L OR ER316L FILLER ROD.
- 6) TOUCH UP POWDER COAT OF AFFECTED AREAS ON BOTH LID AND BASE WITH WHITE POWDER COAT (4.3.5.2) PER DART QSI 005 4.3 OR PRIME/PAINT PER AIRCRAFT MAINTENANCE MANUAL.
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WEIGHT CHANGE:

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NOTE:





IF A BASKET MODIFIED PER DSI 9542 IS GOING TO BE USED TO CARRY LOOSE CARGO THE CUTOUTS IN THE EXPANDED METAL FOR D4317-1 & D4317-3 MUST BE COVERED WITH BLANKING PLATES.

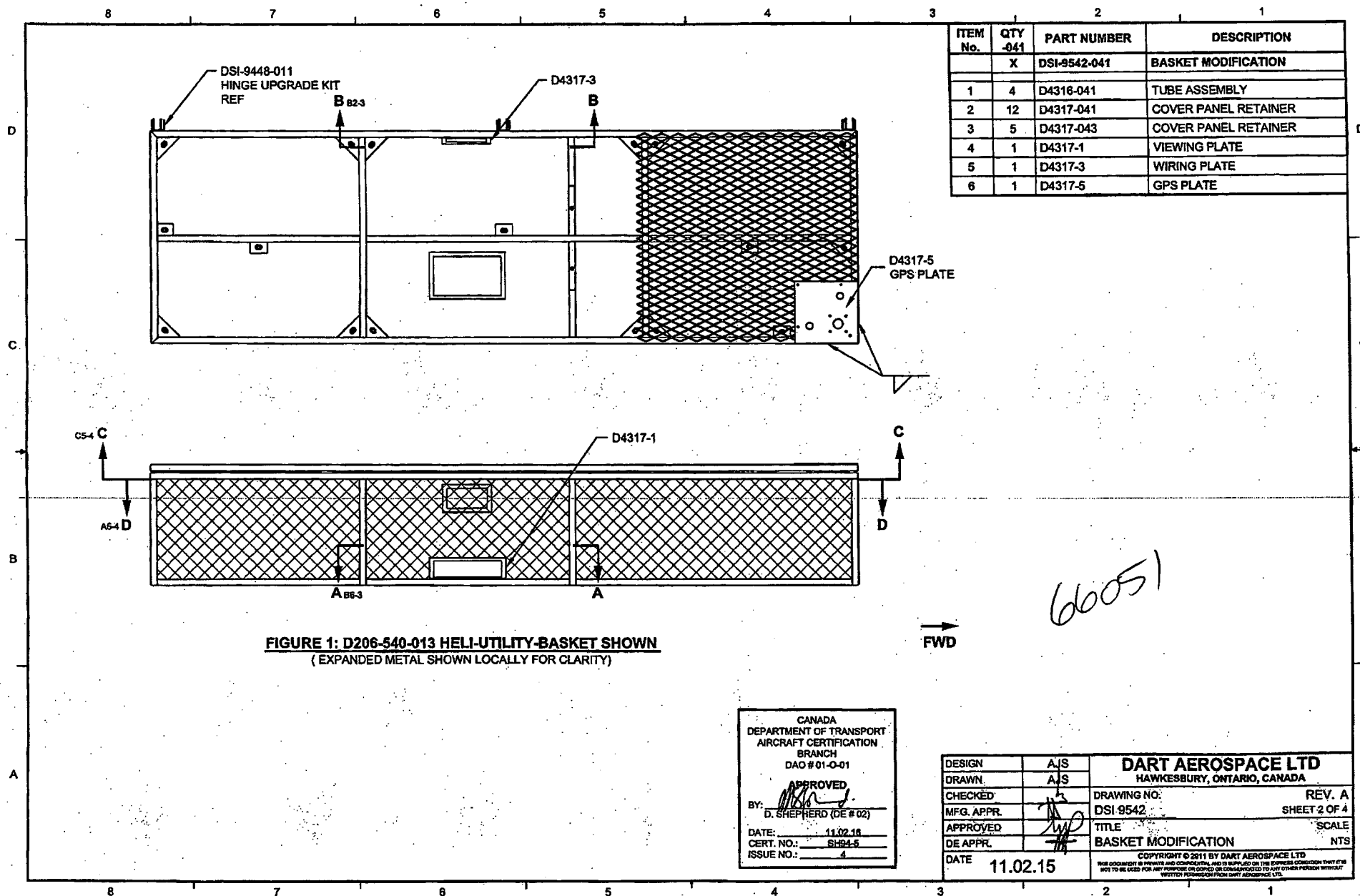
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

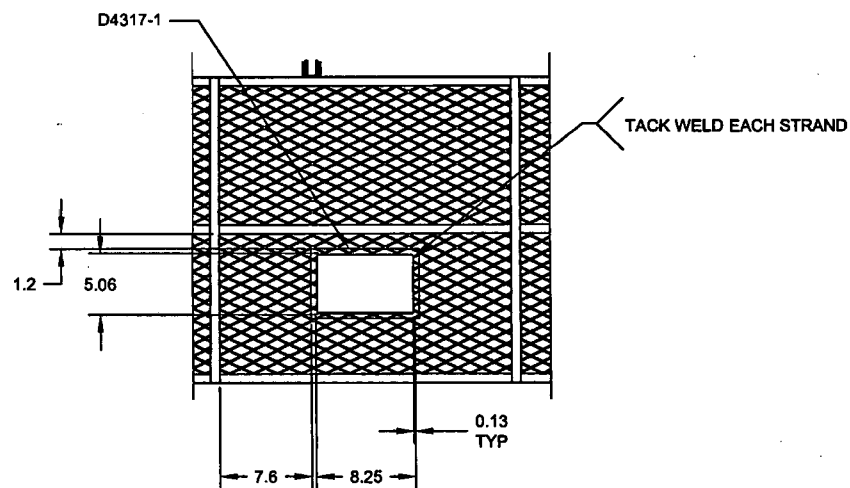
APPROVED

BY: 
D. SHEPHERD (DE # 02)

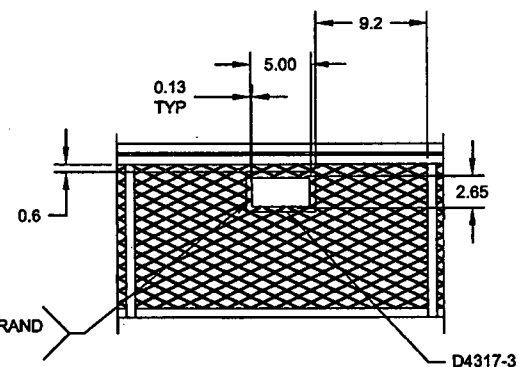
DATE: 11.02.15
CERT. NO.: SH94-5
ISSUE NO.: 4

A	NEW ISSUE	AJS	11.02.15
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9542	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET MODIFICATION	NTS
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SECTION A-A B6-2



SECTION B-B D6-2

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.02.18
CERT. NO.: SH94-5
ISSUE NO.: 4

66051

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. A DSI 9542 SHEET 3 OF 4 TITLE SCALE BASKET MODIFICATION NTS COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PREPARED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.
DRAWN	AJS	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	<i>[Signature]</i>	
APPROVED	<i>[Signature]</i>	
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DATE	11.02.15	

